



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5122-1
Job Sheet 187577



Part No: D5122-1

Job Qty: 8 pcs

Part Name: Center Support, Upper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 1/31/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV A SHEETS 1,2 IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	1/31/19		0.65	14.55	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		MM 209/02/11
110	QC 2	8 pcs	1/31/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		MM 17/02/11
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		



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CANADA
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www.dartaerospace.com

Container No: S153238



Part: D5122-1

Job No: 187577

Serial No/Batch: S153238

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/13/19

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
120 QC 8	8 pcs	1/31/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
130 Packaging 3-1 - Stock - B4B	8 pcs	1/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

mmc 4/2/11

AS 19-2-19

				Packaging 3 - 36 - B4B		DAS
140 QC 21 - SA	8 pcs	1/31/19	0.00	0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-00 FEB 19 2019
Part Op 100 - HAAS1-4 (HAAS CNC Vertical Machine) Machine as per Folio FB324 Descriptions: 110 - QC2 Machining-3 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-3 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: <u>LG053</u>) LOCATION : <u>LG054</u> 140 - QC21 (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D5122-1TRN	Center Support, Upper, Turning Detail	4 pcs (.5 ea)	100-HAAS 4 Axis			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-HAAS 4 Axis	D5122-1TRN	4	0	0		
Part Specifications						
Specifications could not be found.						

Plex 1/22/19 11:40 AM Dart.Hadley.Shannon



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D5122-1**Job Sheet 187577****Part No:** D5122-1**Job Qty:** 8 ea**Part Name:** Center Support, Upper**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/7/18**Job Tracking No:****Due Date:** 1/31/19**Created By:** Jesse White**Type:** Stock**Description:****Note:** DWG REV A SHEETS 1,2 IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Machining-3		
100	CNC Vertical Machining	8 pcs	1/31/19	1/31/19	0.65	14.55	HAAS1-4		
110	QC	8 pcs	1/31/19	1/31/19	0.00	0.00	QC2 Machining-3		
120	QC	8 pcs	1/31/19	1/31/19	0.00	0.00	QC8 Machining-3		
130	Packaging	8 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-2		
140	QC21-SA	8 Ea	1/31/19	1/31/19	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FB324
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5122-1TRN	Center Support, Upper, Turning Detail	4 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5122-1TRN	4	4	0

Part Specifications

Specifications could not be found.

Plex 12/7/18 3:32 PM dart.white.jesse

H4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐																																
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Date :	Sequence #:	QTY Affected :		MRB (QSI042)																																													
Description Work Order Deviation			Disposition																																														
			Completed By																																														
			Lead hand / Supervisor																																														
			QC / QA Coordinator																																														
Root Cause <table style="width: 100%;"> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Preservation</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Human Factors</td><td>☐</td></tr> </table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table style="width: 100%;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
Operator	☐																																																
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Other/Details:																																																	

DART AEROSPACE LTD		Work Order:	
Description: Center Support		Part Number:	D5122-1
Inspection Dwg: D5122	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	1.782	1.202	(1.142)	1.789	1.789	1.788	1.789	1.789
AB	0.090	0.110		.099	.099	.099	.098	.099
AC	0.545	0.565		.553	.553	.554	.554	.553
AD	3.690	3.700		3.693	3.693	3.692	3.693	3.693
AE	3.550	3.560		3.554	3.554	3.555	3.555	3.555
AF	2.453	2.473		2.463	2.463	2.463	2.463	2.461
AG	1.261	1.281		1.272	1.272	1.271	1.271	1.270
AH	0.150	0.210		.185	.185	.190	.190	.190
AI	0.454	0.474		.464	.464	.483	.464	.465
AJ	Ø0.260	Ø0.267		.261Ø	.261Ø	.261Ø	.261Ø	.261Ø
AK	Ø0.188	Ø0.194		.189Ø	.189Ø	.189Ø	.189Ø	.189Ø
AL	3.067	3.077		3.071	3.071	3.070	3.070	3.071
AM	3.990	4.010		4.001	4.001	4.002	4.001	4.002
AN	1.990	2.010		2.002	2.002	2.001	2.002	2.001
AO	Ø0.625	Ø0.630		.625Ø	.625Ø	.625Ø	.625Ø	.625Ø
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				✓				

Measured by:	<i>m.m.</i>	Date:	
Audited by:	<i>2014/02/12 mml</i>	Date:	<i>14/02/14</i>
Preliminary Approval:		Date:	

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	<i>[Signature]</i>

-3/25

DART AEROSPACE LTD		Work Order:	
Description: Center Support		Part Number:	D5122-1
Inspection Dwg: D5122 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	27	38	49	510
HAAS Section								
AA	1.782	1.202		1.140	1.140	1.140		
AB	0.090	0.110		.098	.099	.099		
AC	0.545	0.565		.555	.555	.553		
AD	3.690	3.700		3.693	3.694	3.674		
AE	3.550	3.560		3.555	3.555	3.555		
AF	2.453	2.473		2.463	2.461	2.461		
AG	1.261	1.281		1.271	1.271	1.272		
AH	0.150	0.210		.188	.185	.145		
AI	0.454	0.474		.465	.464	.464		
AJ	Ø0.260	Ø0.267		.261Ø	.261Ø	.261Ø		
AK	Ø0.188	Ø0.194		.189Ø	.189Ø	.189Ø		
AL	3.067	3.077		3.070	3.071	3.071		
AM	3.990	4.010		4.001	4.002	4.002		
AN	1.990	2.010		2.000	2.001	2.001		
AO	Ø0.625	Ø0.630		.625Ø	.625Ø	.625Ø		
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				✓				

Measured by:	<i>M.M.</i>	Date:	2019/02/13
Audited by:	<i>Gravel</i>	Date:	17/02/19
Preliminary Approval:		Date:	

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	<i>[Signature]</i>